DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-004979
Date Inspected: 30-Nov-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1400
OSM Departure Time: 2200
Location: Changxing Island, Shangl

CWI Name:	N/A			**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Tower components

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Deck Panel DP554-001

1. The QA Inspector performed Ultrasonic Testing (UT) on the Partial Joint Penetration (PJP) welds made between the U-ribs (five ribs, two welds per rib ten total welds) and flat plate members of the assembly deck panel identified as DP554-001. The QA Inspector performed the ultrasonic testing using the gate to gate method on the tack weld areas only a total of 240 tack welds were made on the ten welds. The QA Inspector performed the testing on the weld number one through five. The QA Inspector observed several linear indications that appeared to be suspected planar discontinuities located at random locations on the welds and the indications were marked on the steel for Phased-Array Ultrasonic Testing (PAUT) investigation that will be performed at a later time. The observed indication's "Y" location was recorded into the QA Inspector U-Rib to Deck Panel – Weld assessment sheet. The QA Inspector used the ZPMC ultrasonic testing procedure identified as "UT 04-012024 PJP Rib Weld", Ultrasonic Testing for the Detection of Suspected Planar Discontinuities (Cracks) in PJP Welds for the evaluation of observed indications. The QA Inspector completed the testing on the weld number one through five on this shift. The QA Inspector notified Lead QA Inspector Paul Dawson of indications observed and the status of complete testing.

Deck Panel DP579-001

2. The QA Inspector performed UT on the PJP welds made between the U-ribs (five ribs, two welds per rib ten total welds) and flat plate members of the assembly deck panel identified as DP579-001. The QA Inspector performed the ultrasonic testing using the gate to gate method on the tack weld areas only a total of 240 tack welds were made on the ten welds. The QA Inspector performed the testing on the weld number one through three. The QA Inspector observed several linear indications that appeared to be suspected planar discontinuities located at random locations on the welds and the indications were marked on the steel for PAUT investigation. The QA Inspector used the ZPMC ultrasonic testing procedure identified as "UT 04-012024 PJP Rib Weld", Ultrasonic Testing for the Detection of Suspected Planar Discontinuities (Cracks) in PJP Welds for the evaluation of observed indications. The QA Inspector completed the testing on the weld number one through three on this shift. The QA Inspector notified Lead QA Inspector Paul Dawson of indications observed and the status of testing.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer